

Work Order ID 52175

Thursday, September 17, 2009 11:47:47 AM



Page 1

Item ID: D3936-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Divider

Start Date: 9/17/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 9/24/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

RL MF

Date: *09-17*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3936

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3936

Dwg Rev: *A*

Prog Rev: *A*

grain direction per dwg

2-Deburr if necessary

IB 9-9-21

(S)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-9-21

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Item ID: D3936-5	Accept		Setup	Start	
Revision ID: A				Stop	
Item Name: Divider					
Start Date: 9/17/2009	Start Qty: 4.00		Cust Item ID:		
Required Date: 9/24/2009	Req'd Qty: 4.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	2) 802/02/21			(X5)	4		
130 Brake NC Brake NC	Brake NC Bend as per Dwg Memo	0.00 0.00	SB 09/10/05			5	0		
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	2) 801/10/05			(+5)	4		

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Item ID: D3936-5

Accept

Revision ID: A

Item Name: Divider

Start Date: 9/17/2009 Start Qty: 4.00

Required Date: 9/24/2009 Req'd Qty: 4.00




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	4MO	09/10/06		15			
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	5) S	09/10/06		5	1		
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>BA</u> Memo <u>D3936-041</u> <u>B52382</u>	0.00 0.00	8	09/10/06		5	0		

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Page 4

Item ID: D3936-5

Accept

Revision ID: A

Item Name: Divider

Start Date: 9/17/2009 Start Qty: 4.00

Required Date: 9/24/2009 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/10/07
mf
09-10-06

Picklist Print

Page 1

Thursday, September 17, 2009 11:47:47 AM

Work Order ID: 52175



Parent Item: D3936-5RevA



Parent Item Name: Divider



Start Date: 9/17/2009

Required Date: 9/24/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.040 		Purchased	No			100	sf	134.5357	3.8316	4.7845		
6061-T6 .040 Sheet											189-9-21	

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

MAT

134.5357

100742

3.3

102723

7.93

105842

12

106747

12.5

107461

13.1642

109396

22.28

111224

61.8615

19380

1.5

111224

DART AEROSPACE LTD		Work Order:	S2175
Description: DIVIDER		Part Number:	D3936-5
Inspection Dwg: D3936-5 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	✓			
10.598	± .010	10.598	✓			
1.178	± .010	1.180	✓			
12.075	± .010	12.076	✓			
11.667	± .010	11.656	✓			
.785	± .010	.777	✓			
.300	± .010	.301	✓			
1.298	± .010	1.291	✓			
1.698	± .010	1.700	✓			
8.400	± .010	8.400	✓			
1.200	± .010	1.200	✓			
12.375	± .010	12.375	✓			
.040	± .010	.038	✓			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-9-21	Date: 09/09/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

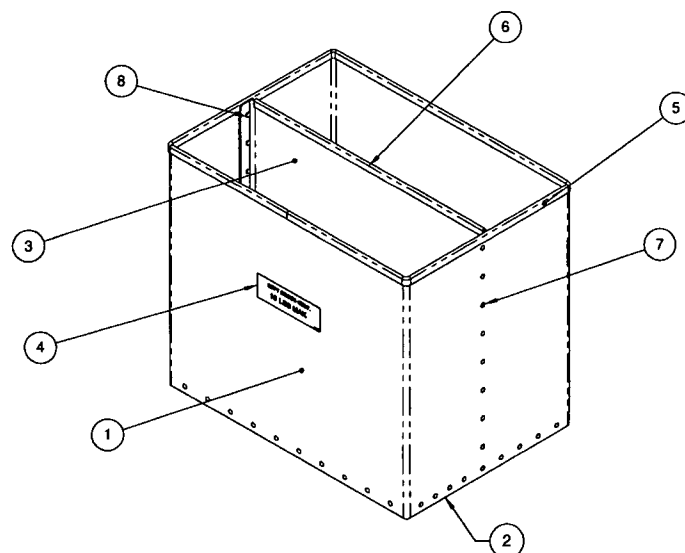
WORK ORDER

NO. 52175

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	1	D3936-1	SIDES
2	1	D3936-3	BOTTOM
3	1	D3936-5	DIVIDER
4	1	D3938-3	PLACARD
5	1	D3941-40	RUBBER CUSHION
6	1	D3941-12	RUBBER CUSHION
7	56	MS20426AD3-4	RIVET
8	8	MS20426AD3-5	RIVET

ASSEMBLY INSTRUCTIONS

1. BEND D3936-1/-3/-5 PARTS PER SHEETS 2-7.
2. POSITION D3936-5 DIVIDER IN PLACE INSIDE THE D3936-1 SIDES AND CLECO IN PLACE.
3. POSITION THE D3936-3 BOTTOM IN PLACE AGAINST THE D3936-5 DIVIDER AND INSIDE THE D3936-1 SIDES.
4. TRANSFER DRILL 10X Ø0.098 (#40 DRILL) HOLES FROM THE D3936-3 BOTTOM TO THE D3936-5 DIVIDER. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
5. TRANSFER DRILL 38X Ø0.098 HOLES FROM D3936-1 SIDES TO D3936-3 BOTTOM. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
6. REMOVE ALL CLECOS AND COUNTERSINK 64X EXTERIOR HOLES Ø0.179 X 100". DEBURR ALL HOLES IN ALL PARTS.
7. REASSEMBLE PARTS USING CLECOS IN EVERY THIRD HOLE TO MAINTAIN ALIGNMENT.
8. RIVET D3936-1 SIDE TO D3936-5 DIVIDER USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
9. RIVET D3936-5 DIVIDER TO D3936-3 BOTTOM USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
10. RIVET D3936-3 BOTTOM TO D3936-1 SIDE USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
11. POWDER COAT ASSEMBLY PER NOTE 2.
12. TEST FIT RUBBER CUSHION TO TOP EDGE OF MAPBOX. TRIM AS REQUIRED FOR PROPER FIT.
13. REMOVE RUBBER CUSHION.
14. APPLY SMALL BEAD OF SILICONE/ADHESIVE TO TOP EDGE OF MAPBOX.
15. SLIDE RUBBER CUSHION OVER EDGE AND PRESS INTO SILICONE/ADHESIVE.
16. WIPE OFF ANY EXCESS SILICONE/ADHESIVE BEFORE IT DRIES/CURES.
17. APPLY D3938-3 PLACARD AS SHOWN.
18. ALLOW SEALANT/ADHESIVE TO CURE/DRY 24 HRS BEFORE SHIPPING PART.



D3936-041 MAPBOX ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3936-041" AND B/N USING A WHITE FINE POINT PAINT MARKER
- 7) WEIGHT: 2.54 lbs

RELEASED
2009-08-28

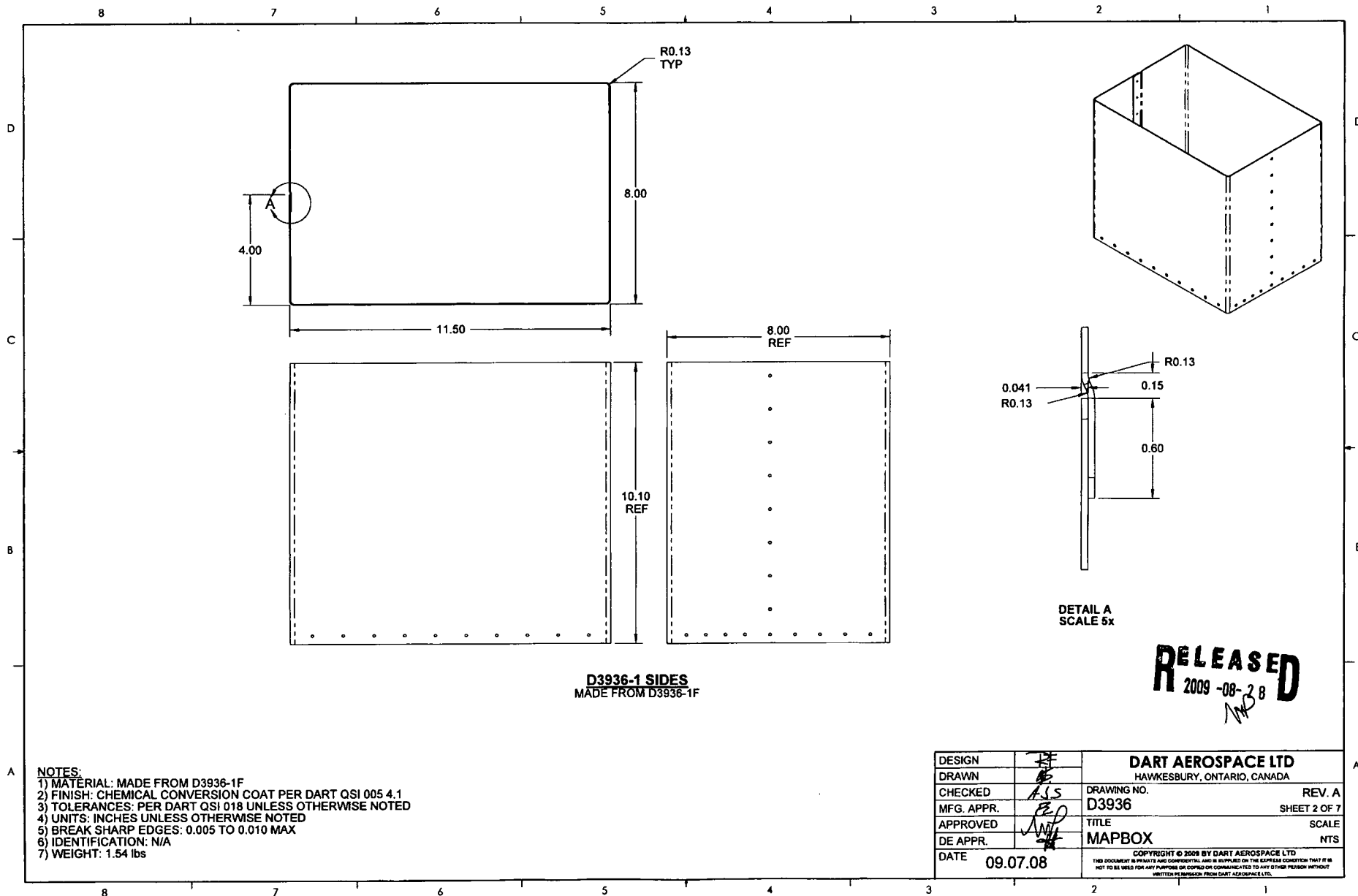
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REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.08		

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HAWKESBURY, ONTARIO, CANADA

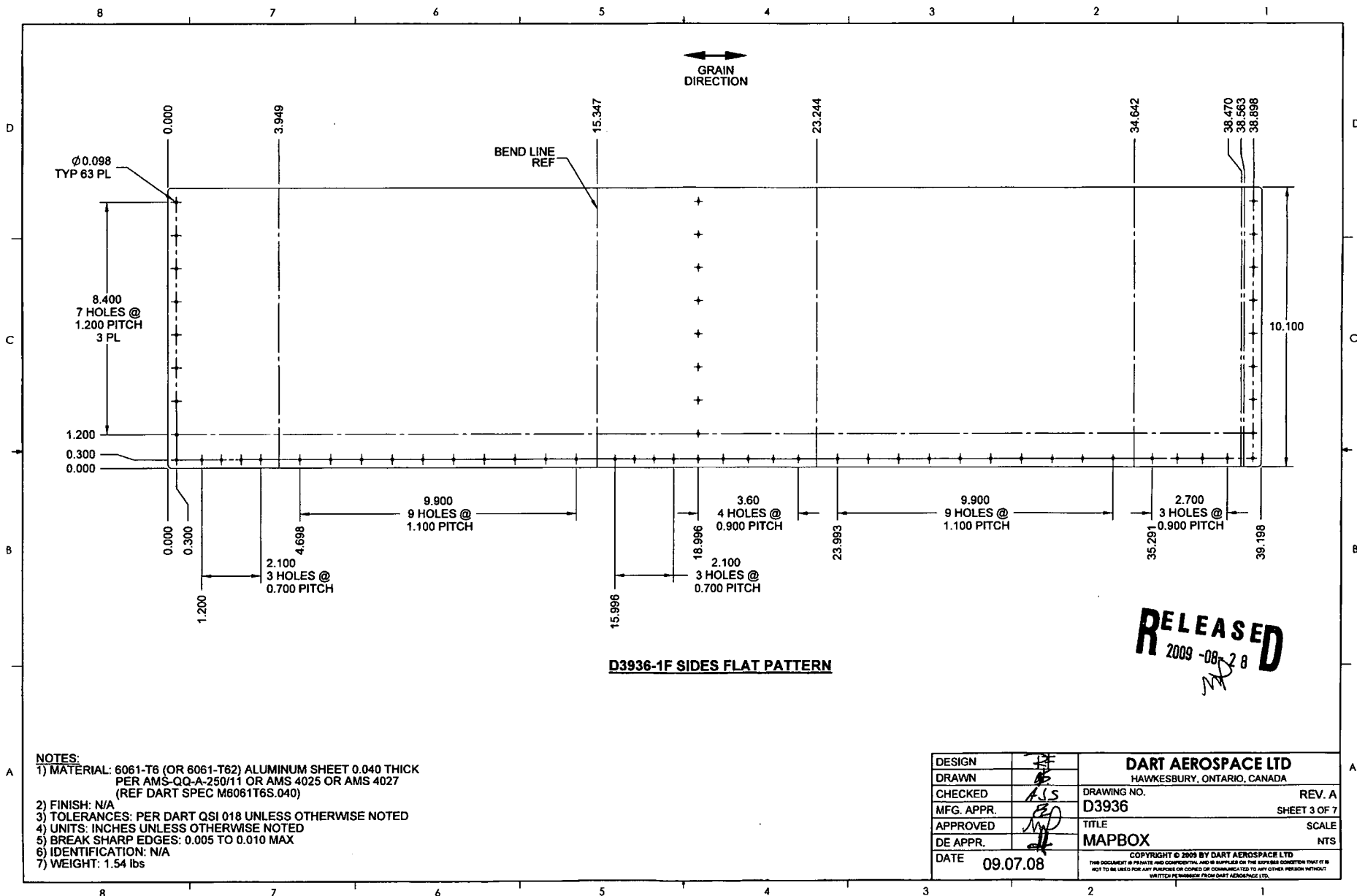
DRAWING NO. D3936
REV. A
SHEET 1 OF 7
TITLE MAPBOX
SCALE NTS

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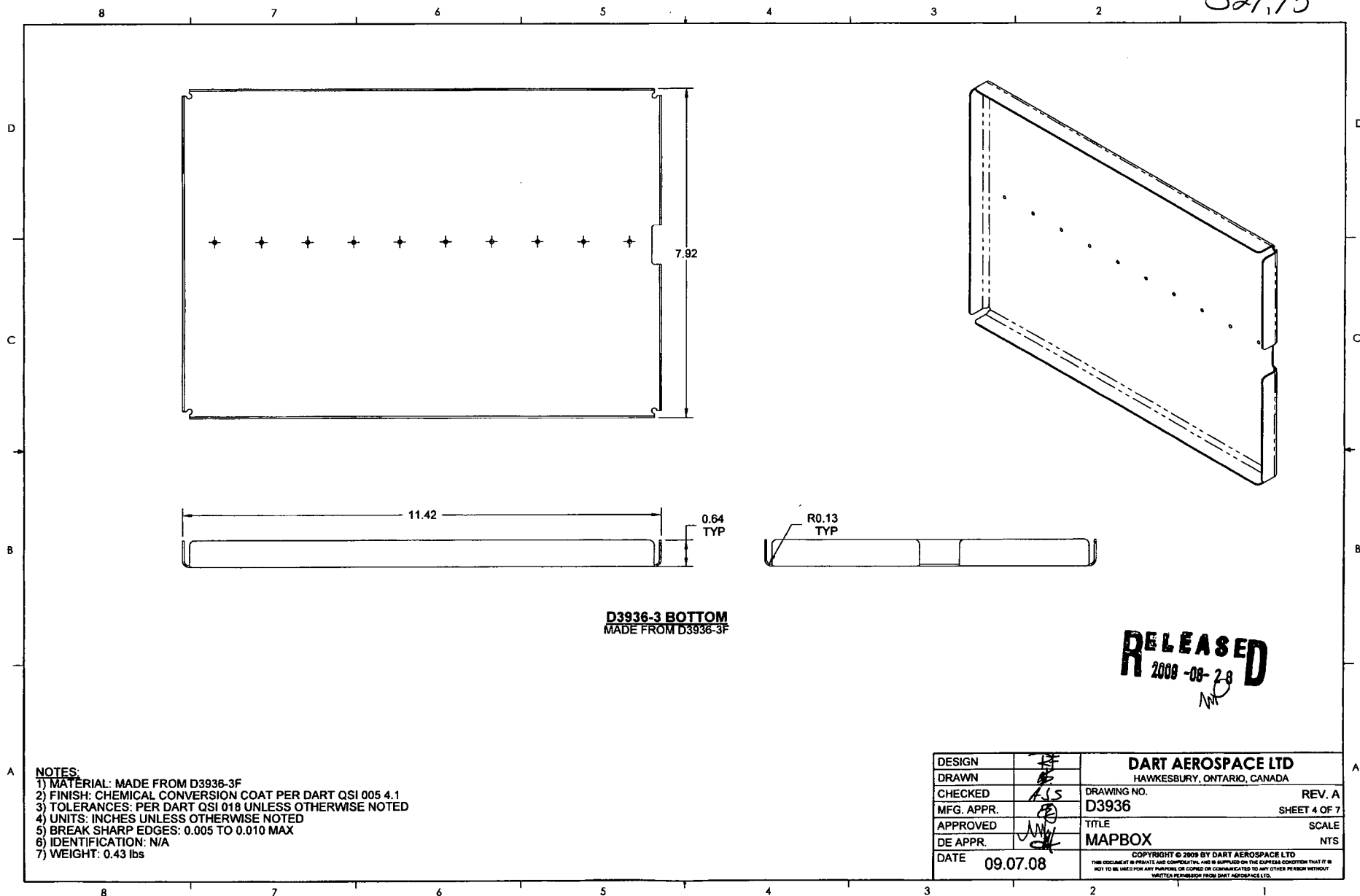
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2009-08-28

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.040)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.54 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3936	SHEET 3 OF 7
APPROVED		TITLE	SCALE
DE APPR.		MAPBOX	NTS
DATE	09.07.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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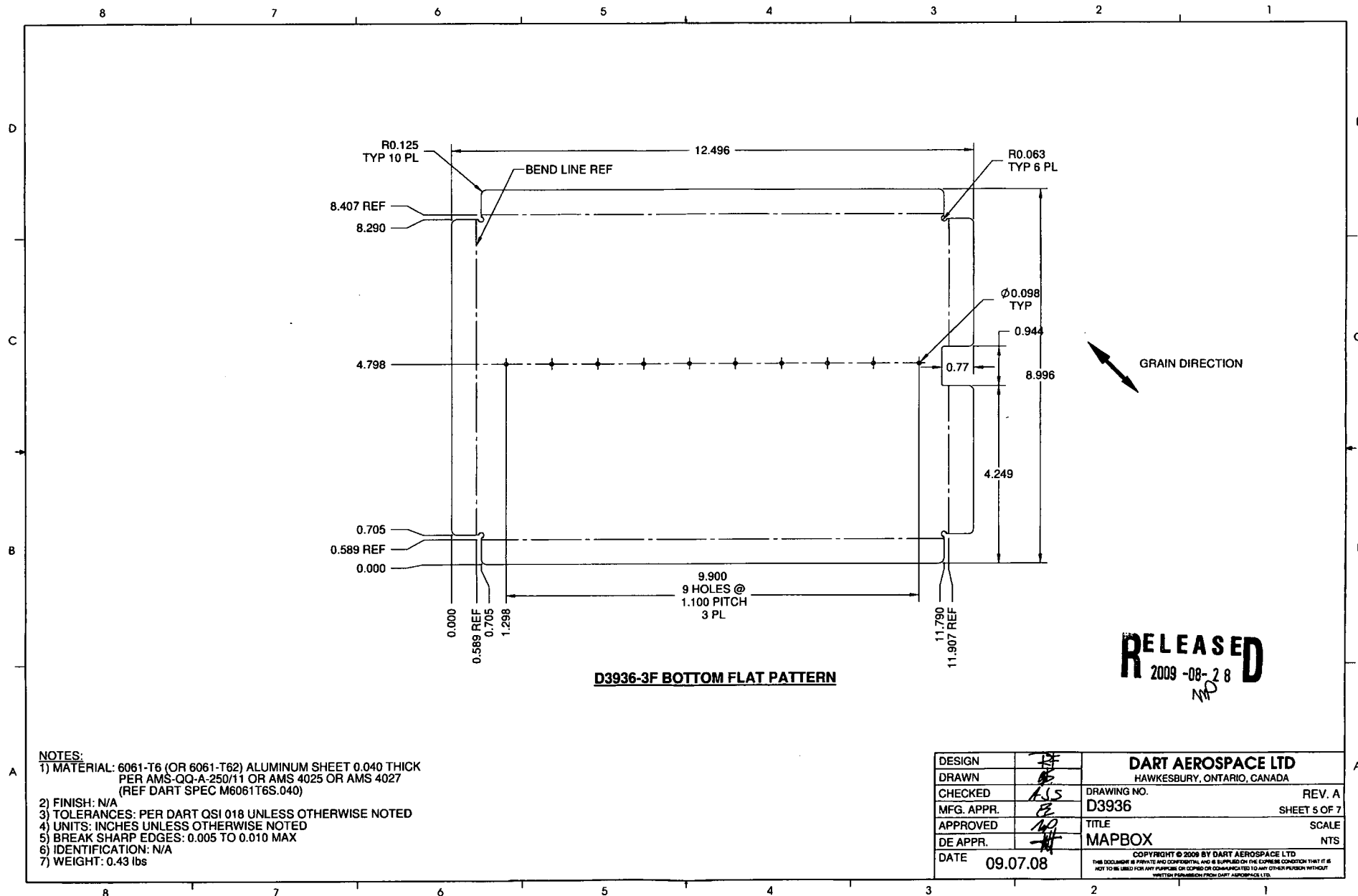
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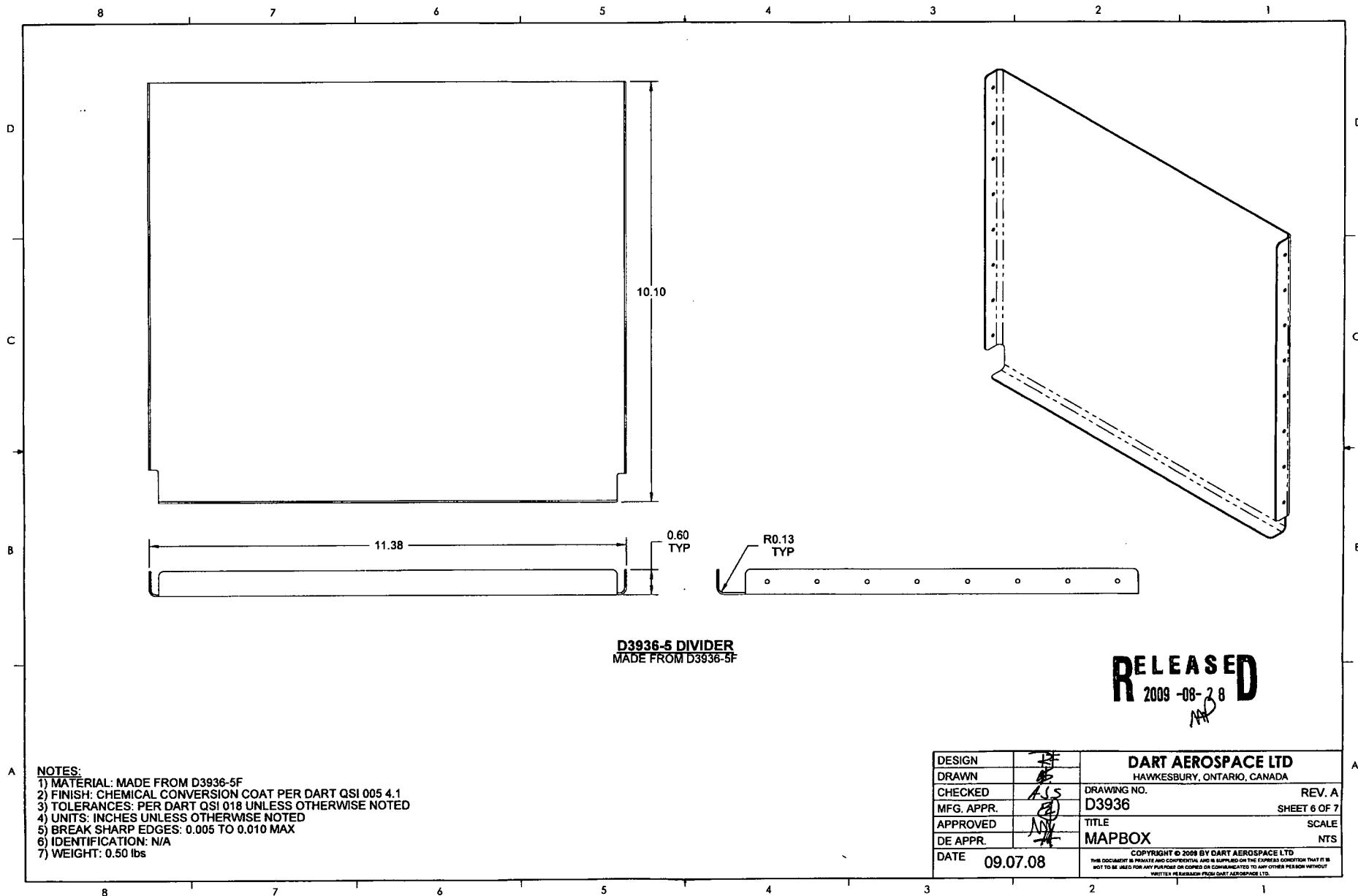
- 1) MATERIAL: MADE FROM D3936-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.43 lbs

52175



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2009-08-28
MS

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NOTES:

- 1) MATERIAL: MADE FROM D3936-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.50 lbs

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